

Work Order ID 66783

Page 1

Monday, February 28, 2011 8:22:32 AM

Item ID: D3315-2

Accept



Setup Start



Revision ID:

Item Name: Wearplate

Stop



Start Date: 2/28/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 3/7/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date: 11-02-28

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3315

Rev B

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D ☒ Dwg Rev: B ☐ Prog Rev: B ☐ 2-Deburr if necessary

10102000

B11-3-4

(6)

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B11-3-4

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

Sulob3104

(6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 66783

Page 2

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Stop



Item Name: Wearplate

Start Date: 2/28/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 3/7/2011 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
	Small Fab								
Small Fab	Memo	0.00							
Small Fab	Deburr if necessary								
				N/A					
140		0.00							
	NC BRAKE								
Brake NC	Memo	0.00							
Brake NC	1- Form using DT8751 Die as per Dwg D3315 Rev: <u>B</u> 2- Form using DT8179 Die and form joggle using DT8157 as per Dwg D3315 Rev: <u>B</u>			SB 11/03/07					
						6			
150		0.00							
	QC6- Inspect dimensions to drawing								
QC	Memo	0.00							
Quality Control				8/10/07					
						46			

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries



Work Order ID 66783

Monday, February 28, 2011 8:22:32 AM



Page 4

Item ID: D3315-2 Accept  Setup Start 
Revision ID: Stop 
Item Name: Wearplate
Start Date: 2/28/2011 Start Qty: 4.00  Cust Item ID:
Required Date: 3/7/2011 Req'd Qty: 4.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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190	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3	0.00							
-----	--	------	--	--	--	--	--	--	--

 Powdercoat	Memo	0.00							
--	------	------	--	--	--	--	--	--	--

Powder Coating	START TIME: 12:30	12:00							
	FINISH TIME: 32:00								

200	QC3- Inspect Part Finish	0.00							
-----	--------------------------	------	--	--	--	--	--	--	--

 QC	Memo	0.00							
--	------	------	--	--	--	--	--	--	--

Quality Control									
-----------------	--	--	--	--	--	--	--	--	--

210	Packaging	0.00							
-----	-----------	------	--	--	--	--	--	--	--

 Packaging	Memo	0.00							
---	------	------	--	--	--	--	--	--	--

Packaging	Identify on inside surface using a permanent fine point marker with the following: <input type="checkbox"/> TCCA-PDA, Dart Aerospace Ltd. <input type="checkbox"/> P/N: D3315-2, B/N: BXXXXX <input type="checkbox"/> For Product Eligibility see PDA04-17 <input type="checkbox"/> and Stock <input type="checkbox"/> Location: 996								
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6X m/l 11/03/22

6 BR 11-3-22

11/3/22 6X SP

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NOTE: Date & initial all entries

Work Order ID 66783

Monday, February 28, 2011 8:22:32 AM



Page 5

Item ID: D3315-2

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearplate

Start Date: 2/28/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 3/7/2011 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

220

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/3/23 [Signature]

MF
11-03-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Monday, February 28, 2011 8:22:39 AM

Page 1

Work Order ID: 66783



Parent Item: D3315-2



Parent Item Name: Wearplate



Start Date: 2/28/2011

Required Date: 3/7/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP: A 05.05.12 New issue KJ/JLM
IPP Rev:B As per Rev B 06-03-24 JLM
IPP RevC now water jet 07-12-06 DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M1010S16GA  1010/1025 sheet 16GA		Purchased	No			100	sf	81.1250	1.695	6.78	10.5		
											B11-3-4		

Location

Loc Qty

Loc Code

MAT	81	
116791	81	
MAT19	-0.125	
111410	0.125	

116791

(6)

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	66783
Description: Wearplate		Part Number:	D3315-2
Inspection Dwg: D3315	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.266 x 0.450	+0.006/-0.001 x +/-0.010	Ø0.266 x 0.450	✓		V HB02	
4.402	+/-0.010	4.400	✓		V	
4.137	+/-0.010	4.143	x		V	
3.550	+/-0.010	3.557	✓		V	
5.464	+/-0.010	5.465	✓		V	
5.214	+/-0.010	5.210	✓		V	
1.224	+/-0.010	1.228	✓		V	
2.57	+/-0.030	2.57	✓		V	
6.273	+/-0.010	6.271	✓		V	
8.224	+/-0.010	8.224	✓		T HB01	
9.515	+/-0.010	9.515	✓		T	
11.429	+/-0.010	11.429	✓		T	
15.474	+/-0.010	15.474	✓		T	
16.379	+/-0.010	16.379	✓		T	
21.360	+/-0.010	21.360	✓		T	
23.474	+/-0.010	23.474	✓		T	
26.273	+/-0.010	26.273	✓		T	
29.42	+/-0.030	29.42	✓		T	
0.060	+/-0.010	0.060	✓		V	
Ø0.300	+0.006/-0.001	Ø0.300	✓		V	

Measured by:	RB	Audited by:	S	Prototype Approval:	N/A
Date:	11-3-4	Date:	11/03/04	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	09.09.28	New Issue	KJ	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

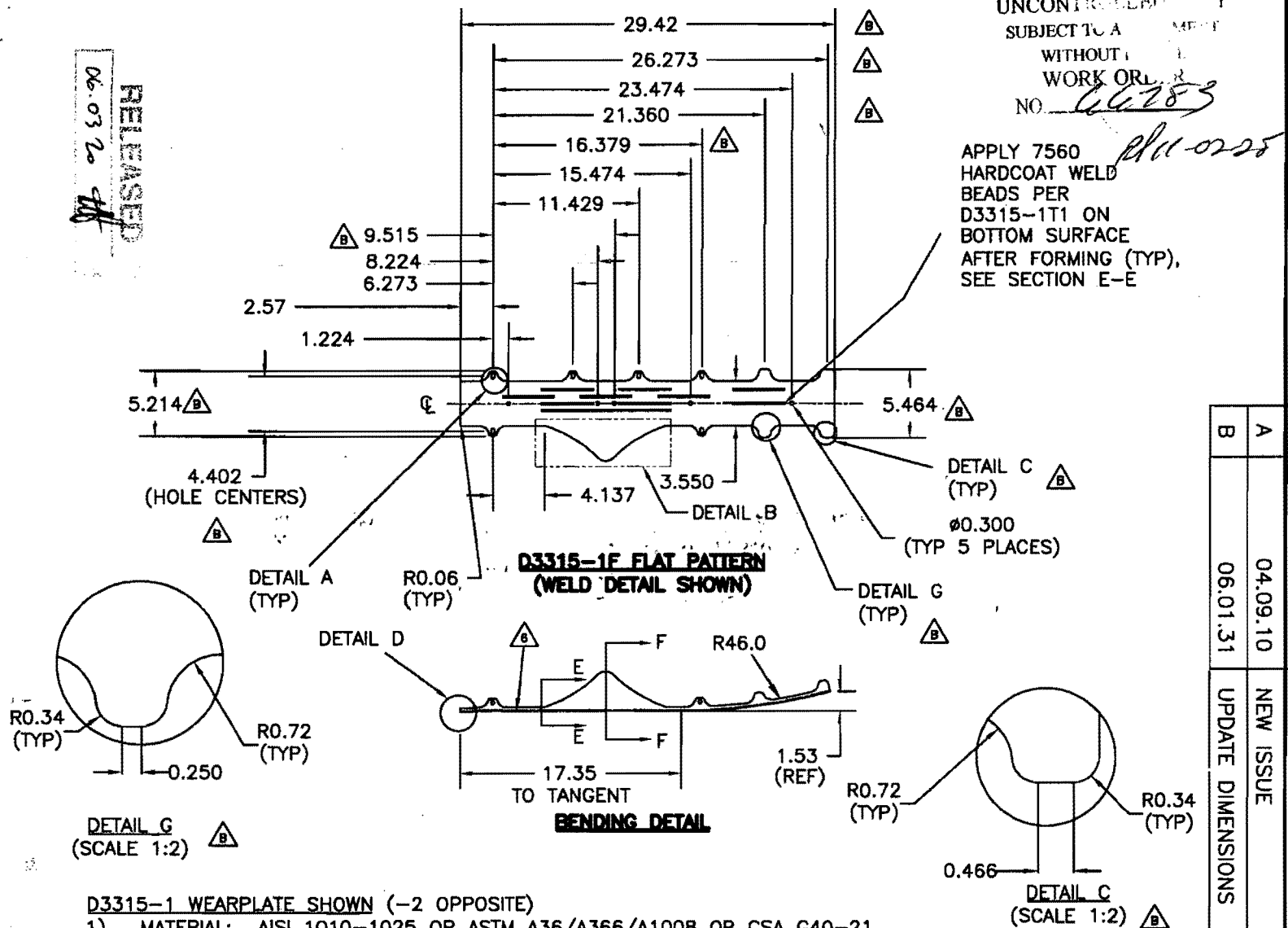
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

RELEASED
06.03.20



D3315-1 WEARPLATE SHOWN (-2 OPPOSITE)

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 16 GAUGE (0.060 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) WELD PER DART QSI 004
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY ON INSIDE SURFACE AS INDICATED
"TCCA-PDA, DART AEROSPACE LTD., P/N D3315-X
B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-17"

UNCONTROLLED COPY
SUBJECT TO A
WITHOUT
WORK OR
NO. 06283

APPLY 7560
HARDCOAT WELD
BEADS PER
D3315-1T1 ON
BOTTOM SURFACE
AFTER FORMING (TYP),
SEE SECTION E-E

DESIGN	DRAWN BY	DART AEROSPACE LTD
06.01.31	04.09.10	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
06.01.31	06.01.31	D3315
DATE	TITLE	WEARPLATE
06.01.31	NEW ISSUE	SCALE
1:12	UPDATE DIMENSIONS	SHEET 1 OF 4
REV. B		

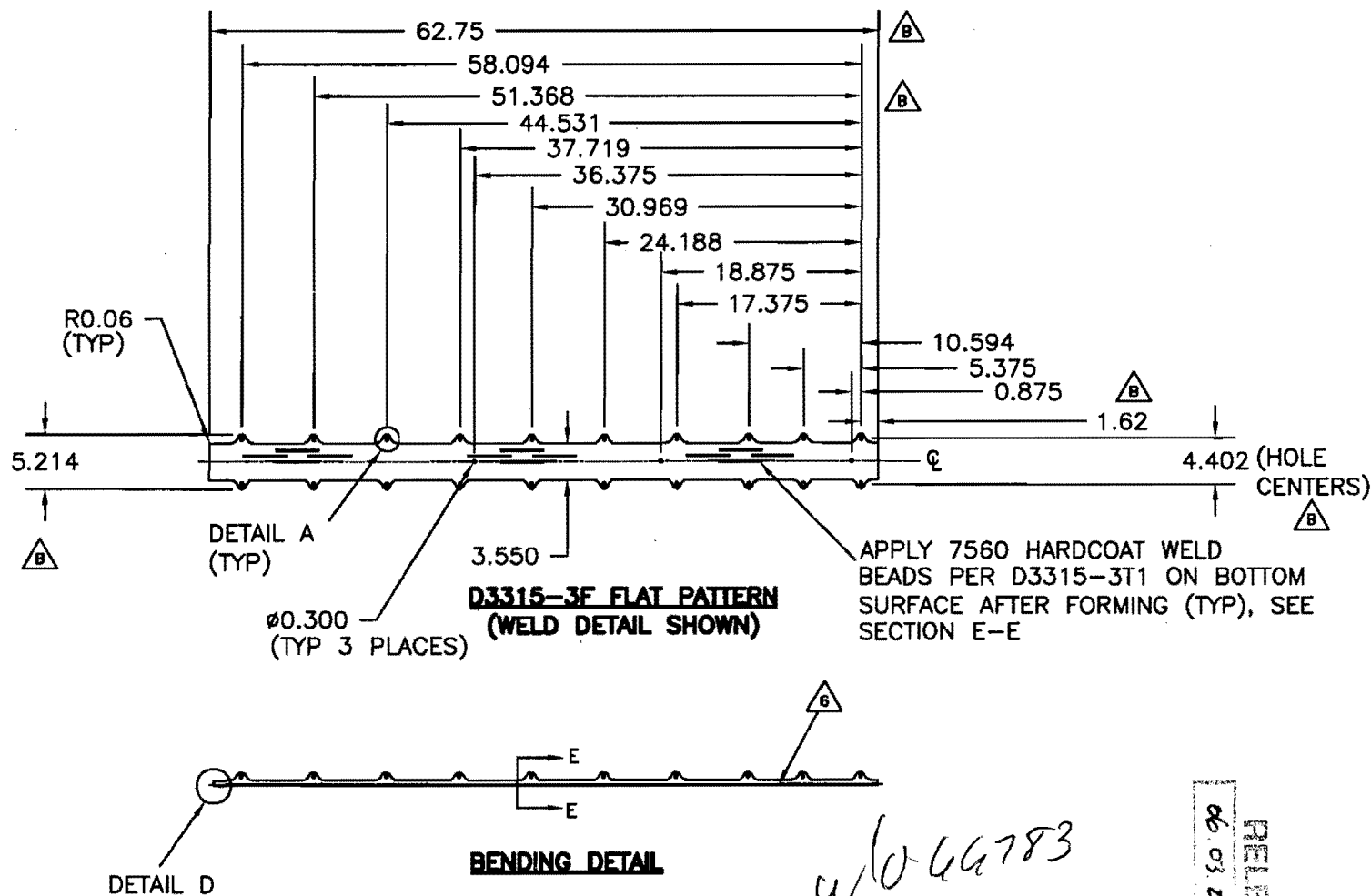
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

D3315-3 WEARPLATE SHOWN (-4 OPPOSITE)

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 16 GAUGE (0.060 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) WELD PER DART QSI 004
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY ON INSIDE SURFACE AS INDICATED
"TCCA-PDA, DART AEROSPACE LTD., P/N D3315-X
B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-17"

DESIGN	DRAWN BY	DART AEROSPACE LTD
04	04	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
04	04	D3315
DATE	TITLE	REV. B
06.01.31	WEARPLATE	SHEET 2 OF 4
		SCALE 1:16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

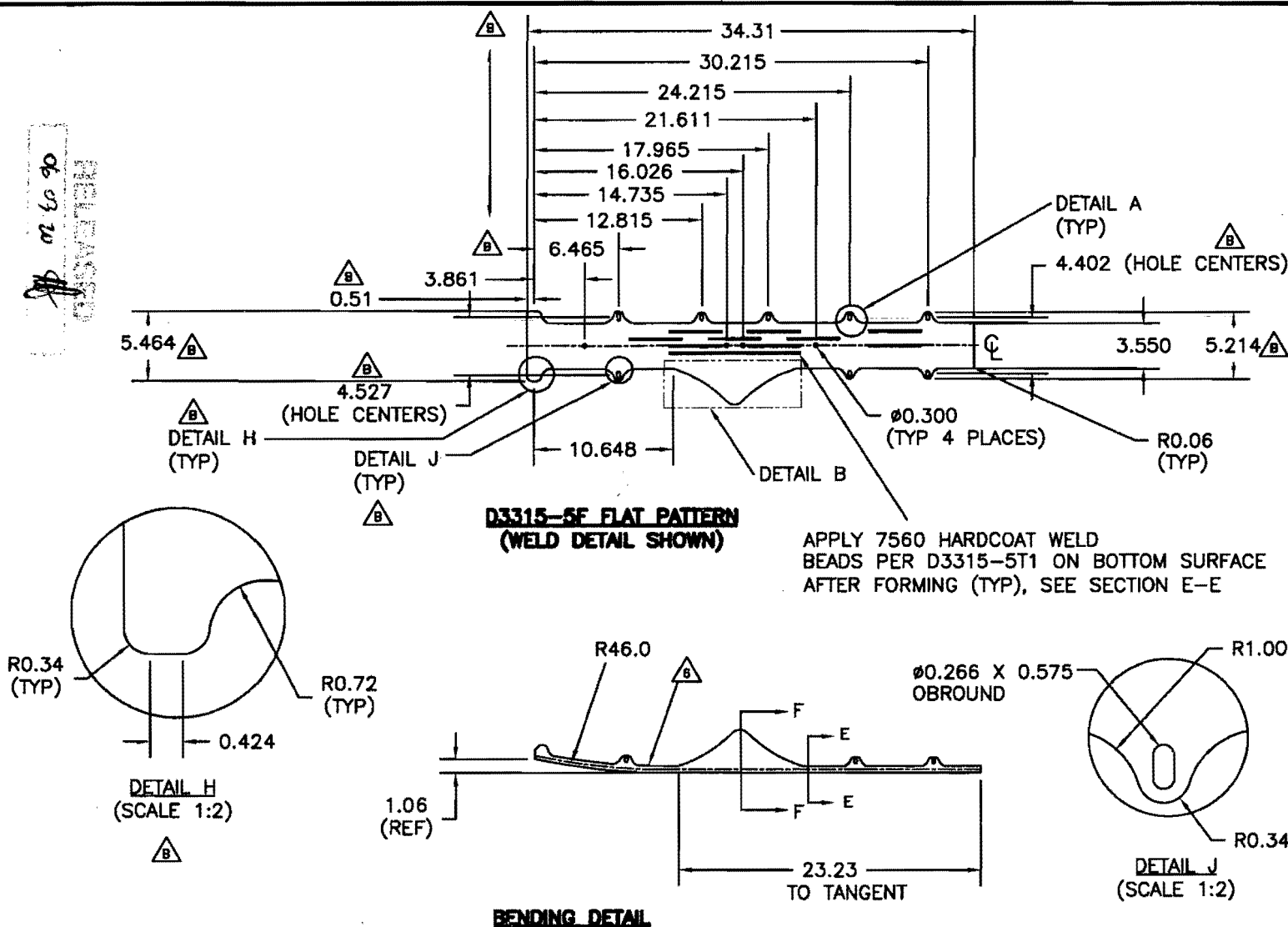
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	D4	DRAWN BY	D4	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED		APPROVED		DRAWING NO.	D3315
DATE	06.01.31	TITLE	WEARPLATE	SHEET	3 OF 4
		SCALE	1:12	REV.	B



D3315-5 WEARPLATE SHOWN (-6 OPPOSITE)

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 16 GAUGE (0.060 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) WELD PER DART QSI 004
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSION ARE IN INCHES
- 6) IDENTIFY ON INSIDE SURFACE AS INDICATED
"TCCA-PDA, DART AEROSPACE LTD., P/N D3315-X
B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-17"

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

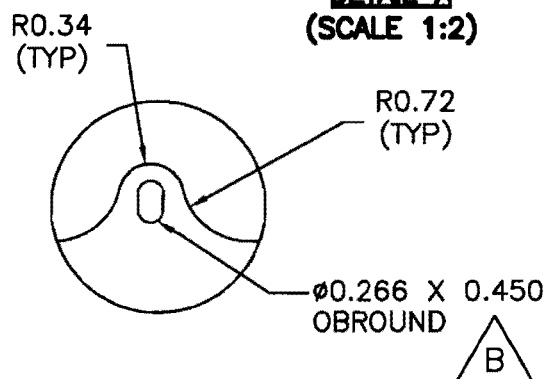
NOTE: Date & initial all entries

DART

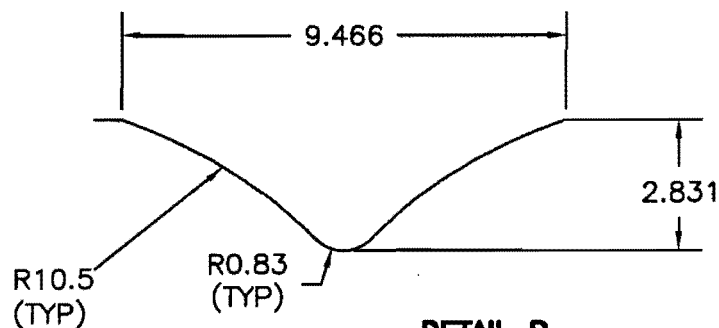
DESIGN	84	DRAWN BY	84	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA
CHECKED		APPROVED		DRAWING NO. D3315
DATE	06.01.31	TITLE	WEARPLATE	REV. B
				SHEET 4 OF 4
				SCALE NTS

w/o 66783

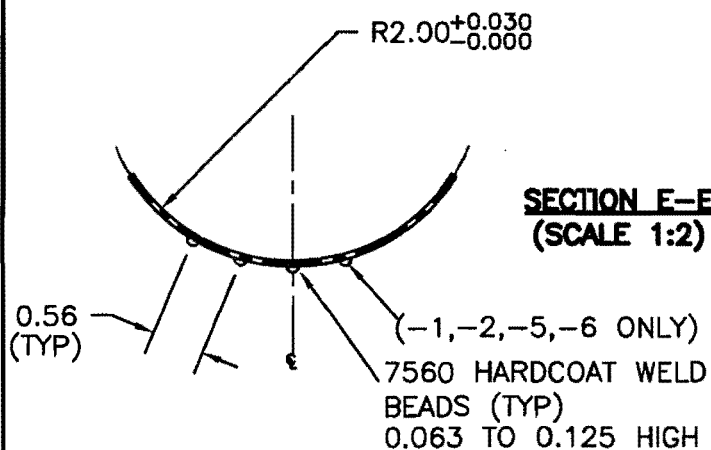
DETAIL A
(SCALE 1:2)



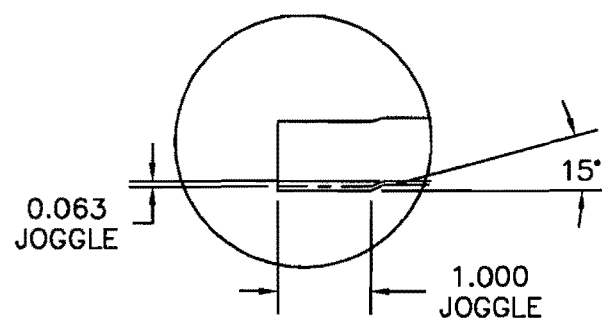
DETAIL B
(SCALE 1:4)



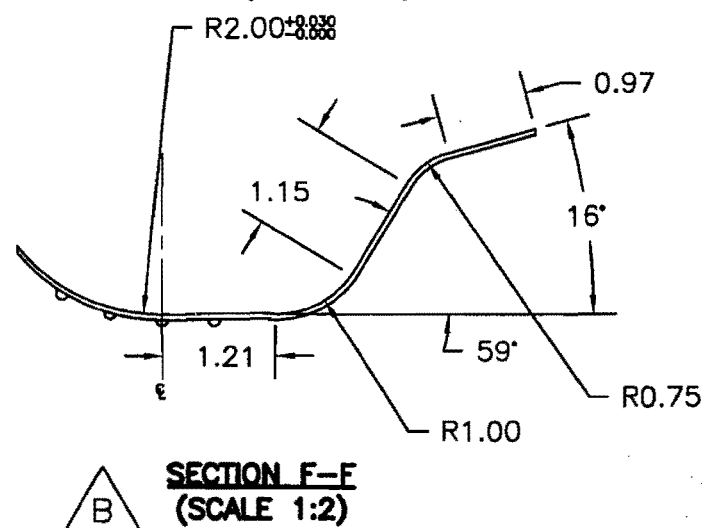
SECTION E-E
(SCALE 1:2)



DETAIL D
(SCALE 1:2)



SECTION F-F
(SCALE 1:2)



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

FIGURE 1: D412-726-111 WEARPLATE KIT
(205/212/412 STANDARD SKIDTUBE)
(LH SKIDTUBE SHOWN, VIEW LOOKING OUTBOARD)
(RH OPPOSITE)

